

Date: Friday, 11/16/2007 7:21:22 AM
 User: Kim Johnston

21.33

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SPACER
 Job Number : 35814
 Estimate Number : 13066
 P.O. Number : N/A Part Number : D36811
 This Issue : 11/16/2007 S.O. No. : N/A Drawing Number : D3681 REV A
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : MACHINED PARTS Drawing Revision : A
 Previous Run : 35738 Material : N/A
 Due Date : 11/26/2007 Qty: 70 Um: 60 Each
 Written By :
 Checked & Approved By :
 Comment : Est Rev A new issue 07-10-30 DD verified by:
 Est Rev:B Ecn 1056 Rev A dwg DD

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6T03125W058 ALUM. SEAMLESS TUBE



Comment: Qty.: 0.0307 f(s)/Unit Total : 1.8396 f(s)

Material:

(M6061T6T0.313W.058)

Batch: M106347

20 07/11/27

2.0 HARDINGE HARDINGE CNC LATHE SMALL



Comment: 1-TURN AS PER FOLIO FA711& DWG D3681

FOLIO REV: _____

DWG REV: A

2-DEBURR AS REQUIRED

20 07/11/27

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

20 07/11/27

70

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

J.F.

07/11/27

70

5.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: LG

20 07/11/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 9/11/08
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 11/16/2007 7:21:23 AM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACER

Job Number: 35814

Part Number: D36811

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



(70)

Comment: FINAL INSPECTION/W/O RELEASE

11/11/28

Job Completion



11/11/28

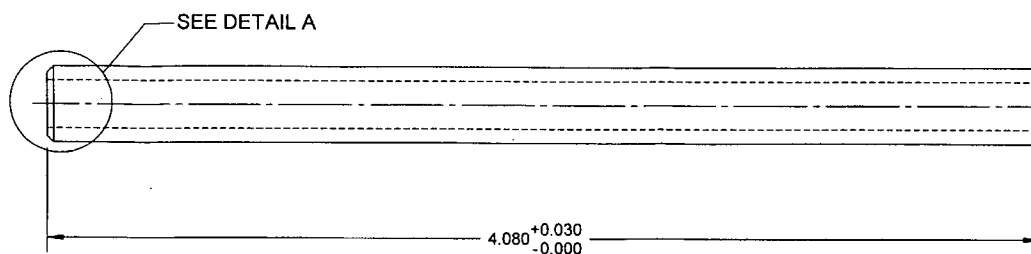
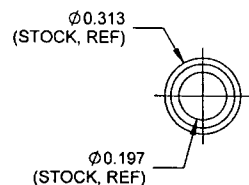
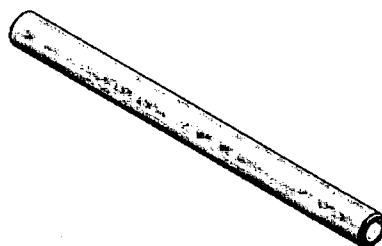
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

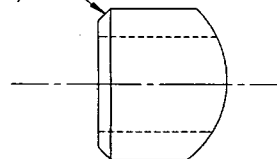
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



0.025 X 45°
CHAMFER
(TYP)



DETAIL A
(SCALE 4 : 1)

D3681-1 SPACER

NO. 35814
WORK ORDER
WITHOUT NOTICE
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY

NOTES:

- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING 0.313" OD X 0.058" WALL
PER WW-T-700/6 OR AMS 4080 OR AMS 4082
OR QQ-A-200/8 OR QQ-A-225/8
(REF. DART SPEC. M6061T6T0.313W.058)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.02 lbs

RELEASED
07-11-08

A		NEW ISSUE		DC	07.11.08
REV.		DESCRIPTION		BY	DATE
DESIGN	SC	DART AEROSPACE USA, INC. PORT HADLOCK, VA			
DRAWN	SC				
CHECKED	MS	DRAWING NO.	REV. /		
MFG. APPR.	EP	D3681	SHEET 1 OF		
APPROVED	W	TITLE	SCALE		
DE APPR.	#	SPACER	2:		
DATE	07.11.08	COPYRIGHT © 2007 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.			

